

Work Order ID 82122

March-23-12 10:44:37 AM

82122

Page 1

Item ID: D2739

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: 350 I Beam

Stop

NS2

Start Date: 23/03/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 06/04/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: ML3

Date: 12/03/12 Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2739

Rev E

100

0.00

100

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Cut D2600-5 to length as per Dwg D2739.
2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739
3-Use uni-bit to open holes to finish size as per Dwg D2739.
4-Bevel Fwd end of extrusion and Deburr holes and ends.
5-Deburr

120

Chemical Conversion Coat per QSI005 4.1

0.00

120

HandFinish

Memo

0.00

Hand Finishing

⑦ 12/03/12-12-2
CF

④ 12/03/12-4-3
CF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82122

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82122

Page 2

Item ID: D2739 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: 350 I Beam
 Start Date: 23/03/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 06/04/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.00							
Quality Control									
140	Identify as per dwg & Stock Location: <u>LG</u>	0.00							
140									
Packaging	Memo	0.00							
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

12-04-3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

March-23-12 10:44:41 AM

Page 1

Work Order ID: 82122

82122

Parent Item: D2739

D2739

Parent Item Name: 350 I Beam

Start Date: 23/03/2012

Required Date: 06/04/2012

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev: C02.11.28ReformatKJ

IPP Rev: D 06-03-21 As Per Rev C JLM

IPP Rev: E 07-07-28 As per Rev D JLM Verified By: IPP Rev:F

10.11.02 as per revE DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-5-108		Manufactured	No			100	Each	177.0000	1	4			

D2600-5-108

Extrusion 'I Beam' thin

Location

LG

47814
73909

Loc Qty

177
20
157

Loc Code

4 76-1242

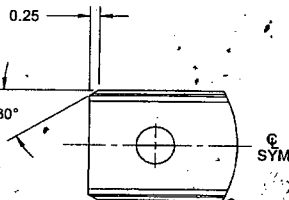
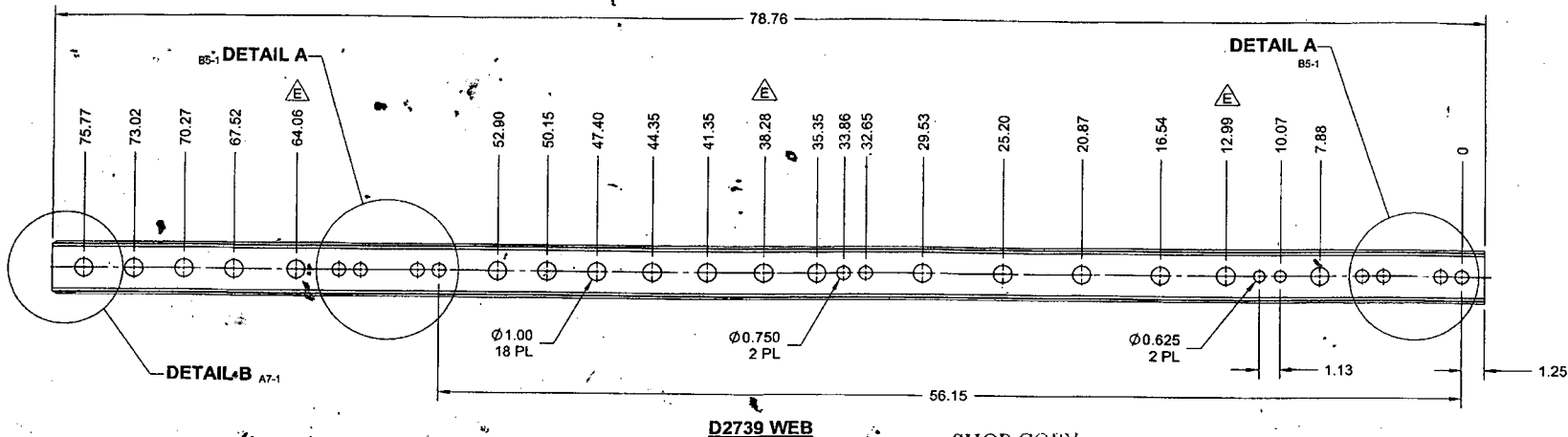
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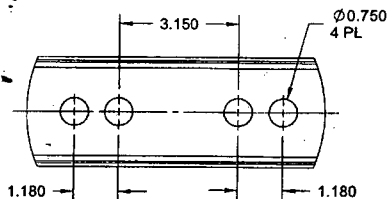
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



DETAIL B
SCALE 3X



DETAIL A
SCALE 3X

NOTES:

- 1) MATERIAL: MAKE FROM D2600-5 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART P/N "D2739" AND B/N PER DART QSI 044 6.1
- 7) WEIGHT: 3.41 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82122 *MLJ*
12/03/23

RELEASED
2010-11-01

E	ADD/MOVE HOLES FOR D4154 WEARPLATE: 38.28 WAS 38.35 (D5-1), 64.08 WAS 64.77 (D7-1), ADD HOLE (D3-1)	CP	10.10.08
D	ADD BEVEL TO FWD END; ADD DETAIL B	CB	07.05.29
C	ADD/MOVE HOLES FOR COMPATIBILITY WITH APICAL FLOATS	PH	06.01.05
B	CHANGE HOLES FOR COMPATIBILITY WITH AIRCRUISER FLOATS	CP	98.11.18
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	<i>JP</i>		
CHECKED	<i>JP</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>JP</i>	D2739	SHEET 1 OF 1
APPROVED	<i>JP</i>	TITLE	SCALE
DE APPR.	<i>JP</i>	WEB	NTS
DATE	10.10.08	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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